



Designation: ~~F621-02~~ Designation: **F 621 – 08**

Standard Specification for Stainless Steel Forgings for Surgical Implants¹

This standard is issued under the fixed designation F 621; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers the requirements of forged stainless steel for surgical implants when the material forged conforms to Specifications F 138 (UNS S31673), ~~Specification F 1314 (UNS S21910), or Specification F1586~~ F 1586 (UNS S31675), F 2229 (UNS S31675), S29108, or F 2581 (UNS R56320).

1.2 The values stated in inch-pound units are to be regarded as the standard.

2. Referenced Documents

2.1 ASTM Standards:²

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A 473 Specification for Stainless Steel Forgings

E 8 Test Methods for Tension Testing of Metallic Materials

~~E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials³~~ 10 Test Method for Brinell Hardness of Metallic Materials

~~E 12 Test Methods for Determining Average Grain Size³~~ 18 Test Methods for Rockwell Hardness of Metallic Materials

~~E 165 Practice for Liquid Penetrant Examination~~ 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E 92 Test Method for Vickers Hardness of Metallic Materials

E 112 Test Methods for Determining Average Grain Size

E 165 Test Method for Liquid Penetrant Examination

E 353 Test Methods for Chemical Analysis of Stainless, Heat-Resisting, Maraging, and Other Similar Chromium-Nickel-Iron Alloys

F 138 Specification for Wrought-18Chromium-14Nickel-2.5Molybdenum Stainless Steel Bar and Wire for Surgical Implants (UNS S31673)

F 601 Practice for Fluorescent Penetrant Inspection of Metallic Surgical Implants

~~F 1314 Specification for Wrought Nitrogen Strengthened-22Chromium-13Nickel-5Manganese-2.5Molybdenum Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S21910)⁶~~

1314 Specification for Wrought Nitrogen Strengthened 22 Chromium 13 Nickel 5 Manganese 2.5 Molybdenum Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S20910)

~~F 1586 Specification for Wrought Nitrogen Strengthened-21Chromium-10Nickel-3Manganese-2.5Molybdenum Stainless Steel Alloy Bar for Surgical Implants (UNS S31675)⁶~~

2-2 Specification for Wrought Nitrogen Strengthened 21 Chromium 10 Nickel 3 Manganese 2.5 Molybdenum Stainless Steel Alloy Bar for Surgical Implants (UNS S31675)

F 2229 Specification for Wrought, Nitrogen Strengthened 23Manganese-21Chromium-1Molybdenum Low-Nickel Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S29108)

F 2581 Specification for Wrought Nitrogen Strengthened 11Manganese-17Chromium-3Molybdenum Low-Nickel Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S29225)

2.2 ISO Standards:

ISO 5832-1 Implants for Surgery—Metallic Materials Part 1: Wrought Stainless Steel

¹ This specification is under the jurisdiction of ASTM Committee F04 on Medical and Surgical Materials and Devices and is the direct responsibility of Subcommittee F04.12 on Metallurgical Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* Vol 01-03, volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.

ISO 5832-9 Implants for Surgery—Metallic Materials Part 9: Wrought High Nitrogen Stainless Steel³
ISO 5832-1 Implants for Surgery—Metallic Materials Part 1: Wrought Stainless Steel
ISO 5832-9 Implants for Surgery—Metallic Materials Part 9: Wrought High Nitrogen Stainless Steel
ISO 9001 Quality Managements Systems—Requirements

2.3 *American Society for Quality Standard*:⁴

ASQC C1 Specifications of General Requirements for a Quality Control Program

3. Ordering Information

3. Inquiries and orders for forgings under this specification shall include the following information:

- 3.1.1 Quantity;
- 3.1.2 ASTM designation and date of issue;
- 3.1.3 ASTM material (alloy) standard and date of issue;
- 3.1.4 Condition;
- 3.1.5 Mechanical properties;
- 3.1.6 Finish;
- 3.1.7 Applicable dimensions or drawing number;
- 3.1.8 Special tests, if any, and
- 3.1.9 Other special requirements. Terminology

3.1 *Definitions of Terms Specific to This Standard*:

3.1.1 *lot*—the total number of forgings produced from the same heat under the same conditions at essentially the same time.

4. General Requirements for Delivery

4.1 Material furnished to this specification shall conform to the applicable requirements in the current edition of Specification A473 Ordering Information

4.1 Inquiries and orders for forgings under this specification shall include the following information:

- 4.1.1 Quantity;
- 4.1.2 ASTM designation and date of issue;
- 4.1.3 ASTM material (alloy) standard and date of issue;
- 4.1.4 Condition;
- 4.1.5 Mechanical properties;
- 4.1.6 Finish;
- 4.1.7 Applicable dimensions or drawing number;
- 4.1.8 Special tests, if any, and
- 4.1.9 Other special requirements.

5. General Requirements for Delivery

5.1 Material furnished to this specification shall conform to the applicable requirements in the current edition of Specification A 473.

5.2 In the case where a conflict exists between this specification and that listed in 4.1.1, this specification shall take precedence.

5.6. Materials and Manufacture

5.6.1 Material for forgings shall be bars or wire fabricated in accordance with Specifications F 138, F 1314, F 1586, F 2229, or F 1586 F 2581, generally in the unannealed condition with a finish suitable for forging.

5.6.2 The material shall be forged by hammering, pressing, rolling, extruding, or upsetting, and shall be processed, if practicable, so as to cause metal flow during the hot-working operation to be in the most favorable direction for resisting stresses encountered in service, as may be indicated to the supplier by the purchaser.

5.6.3 Forgings shall be free of splits, scale, cracks, ~~inequalities~~, flaws, and other imperfections not consistent with good commercial practice (see Note 1). ~~Offset or mismatch allowance, dependent upon part size and configuration, shall be within standard forging tolerances.~~ Offset or mismatch allowance, dependent upon part size and configuration, shall be within standard forging tolerances if not specified on the part drawing.

NOTE 1—Compliance to these requirements may be verified by Practices E 165 or F 601 or other suitable methods.

³ Annual Book of ASTM Standards, Vol 03.01.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁴ Annual Book of ASTM Standards, Vol 03.03.

⁴ Available from American Society for Quality (ASQ), 600 N. Plankinton Ave., Milwaukee, WI 53203, <http://www.asq.org>.

5.4 After all hot working operations, the forgings shall receive an annealing treatment, when necessary, by heating the parts to an appropriate elevated temperature for a specified dwell time followed by rapid cooling to meet the applicable metallurgical requirements specified by the purchaser.

5.5 Optional identification marks, including the purchaser's logo, material designation, heat code number, and impression number, may be placed upon each forging, the method and location of which shall be as specified by the purchaser.

6. Chemical Composition

6.1 The stainless steel forgings shall conform to the chemical requirements prescribed in the applicable alloy specification: F 138, F 1314, or F 1586.

6.2 For referee purposes, Test Methods E 353

6.4 After all hot working operations, the forgings shall receive an annealing treatment, when necessary, by heating the parts to an appropriate elevated temperature for a specified dwell time followed by rapid cooling to meet the applicable metallurgical requirements specified by the purchaser.

6.5 Heat treating the alloys specified in Specifications F 2229 and F 2581 in an oxidizing atmosphere results in the formation of a magnetic (ferritic) surface layer on the heat-treated product. This surface layer shall be removed from the finished product prior to its use as a medical or surgical device. To avoid this effect during processing, heating cycles shall be kept as short as possible.

6.6 Optional identification marks, including the purchaser's logo, material designation, heat code number, and impression number, may be placed upon each forging, the method and location of which shall be as specified by the purchaser.

7. Chemical Composition

7.1 The stainless steel forgings shall conform to the chemical requirements prescribed in the applicable alloy specification: F 138, F 1314, F 1586, F 2229, or F 2581, as applicable.

7.2 For referee purposes, Test Methods E 353 shall be used.

7. Mechanical Requirements

7.1 The mechanical properties of forgings shall be tested by the forger and shall comply with the minimum mechanical properties as specified in Specifications F 138, F 1314, or F 1586.

7.1.1 Test specimens shall be taken from a representative forging if possible, or from a representative forged test bar, only if the configuration does not lend itself to yielding the required specimen. Any specially forged test bar must be in the same condition as the forgings it represents.

7.2 When desired, Rockwell hardness may be specified by the purchaser and shall be determined in accordance with Test Methods E 18

8. Mechanical Requirements

8.1 The mechanical properties of forgings shall be tested by the forger and shall comply with the minimum mechanical properties as specified in Specifications F 138, F 1314, F 1586, F 2229, or F 2581, as applicable.

8.1.1 Test specimens shall be taken from a representative forging if possible. A representative test bar may only be used if the configuration is such that a test bar cannot be obtained. Any specially forged test bar must be in the same condition as the forgings it represents.

8.2 When desired, hardness may be specified on the purchase order or drawing and shall be determined in accordance with Test Methods E 10, E 18, or E 92.

8.3 The mechanical properties shall be determined in accordance with Test Methods E 8.

8. Special Tests

8.1

8.4 *Number of Tests:*

8.4.1 Perform at least one tension test from each lot in the longitudinal direction, or as indicated on the part drawing. Should this test result not meet the specified requirements, test two additional test pieces representative of the same lot, in the same manner, for each failed test piece. The lot shall be considered in compliance only if both additional test pieces meet the specified requirements.

8.4.2 Tensile tests results for which any specimen fractures outside the gage length shall be considered acceptable if both the elongation and reduction of area meet the minimum requirements specified. Refer to Test Methods E 8, sections 7.11.4 and 7.12.5.

8.4.2.1 If either the elongation or reduction of area is less than the minimum requirement, discard the test and retest. Retest one specimen for each specimen that did not meet the minimum requirements.

9. Special Tests

9.1 *Corrosion Tests*— Forgings furnished to this specification shall be capable of passing the test for intergranular corrosion susceptibility in accordance with Practice E of Practices A 262.

8.2